

Date: Friday, 7/20/2007 10:22:32 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 33714  
 Estimate Number : 10721  
 P.O. Number : N/A Part Number : D34637  
 This Issue : 7/20/2007 S.O. No. : N/A Drawing Number : D3463 REV.B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B  
 Previous Run : 33507 Material : N/A  
 Due Date : 7/27/2007 Qty: 10 Um: EACH  
 Written By :  
 Checked & Approved By :  
 Comment : EST REV A 05.11.18 new issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W120 Inventory



Comment: Qty.: 1.0000 f(s)/Unit Total: 10.0000 f(s)  
 AISI 304 SS seamless tubing 0.750 OD X 0.120 wall  
 (M304TR0750W120)  
 Batch: M103240

07-07-23 FF

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Cut to 13.875"  
 2-Deburr  
 3-Bend end as per dwg D3463

FF 07-07-30

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/30 x8

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 1-Mill as per dwg D3463  
 2-Drill hole & ream to 0.4385" as per dwg D3463  
 3-Deburr

07-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/08/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/20/2007 10:22:33 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33714

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



*EC 07.07.30*

⑧

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



*EC 07.07.31*

⑧

Comment: SECOND CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Large fab.*

*EC 07.07.31*

⑧

8.0

QC21

FINAL INSPECTION/W/O RELEASE



⑧

Comment: FINAL INSPECTION/W/O RELEASE

*EC 07.08.01*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

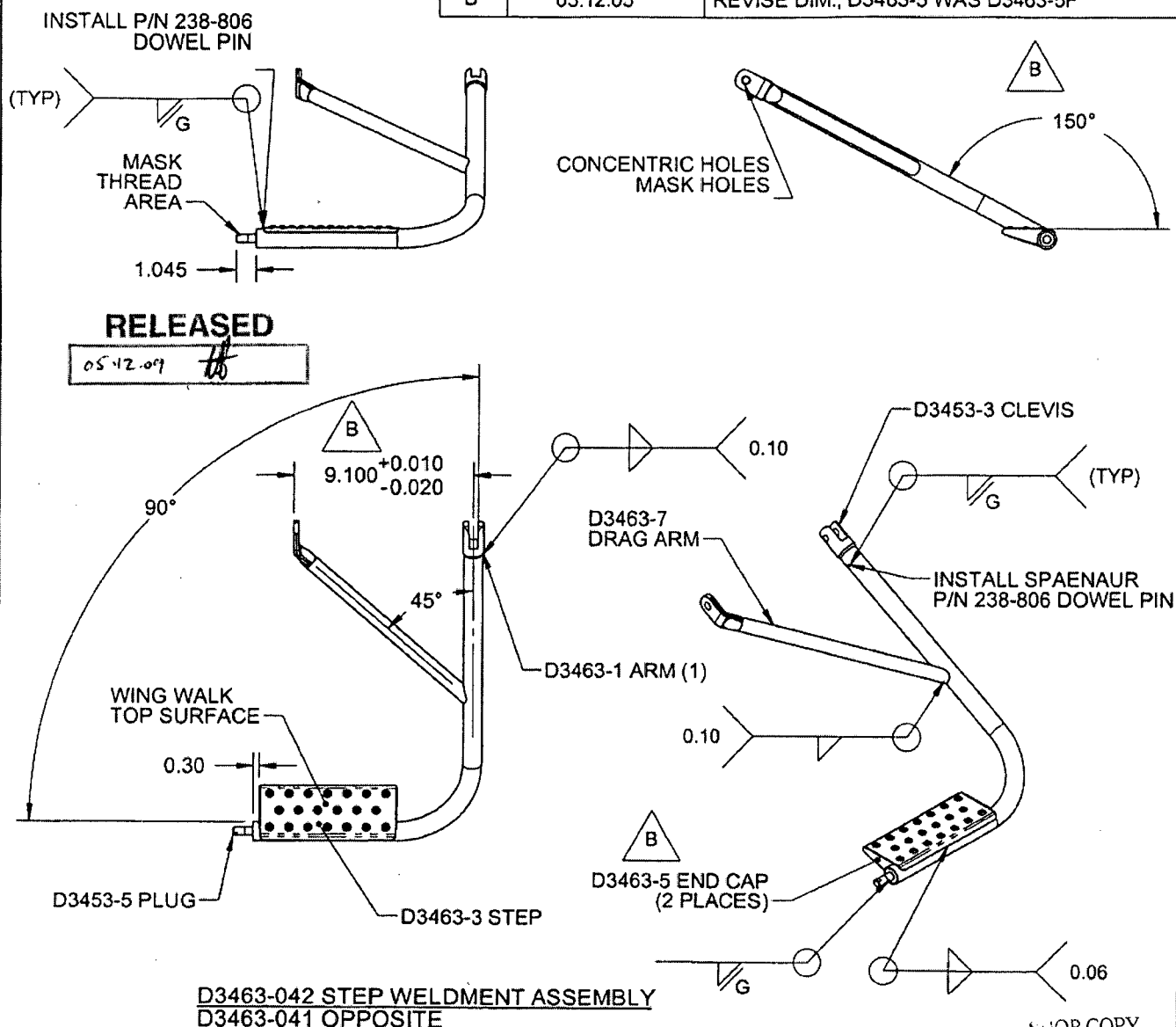
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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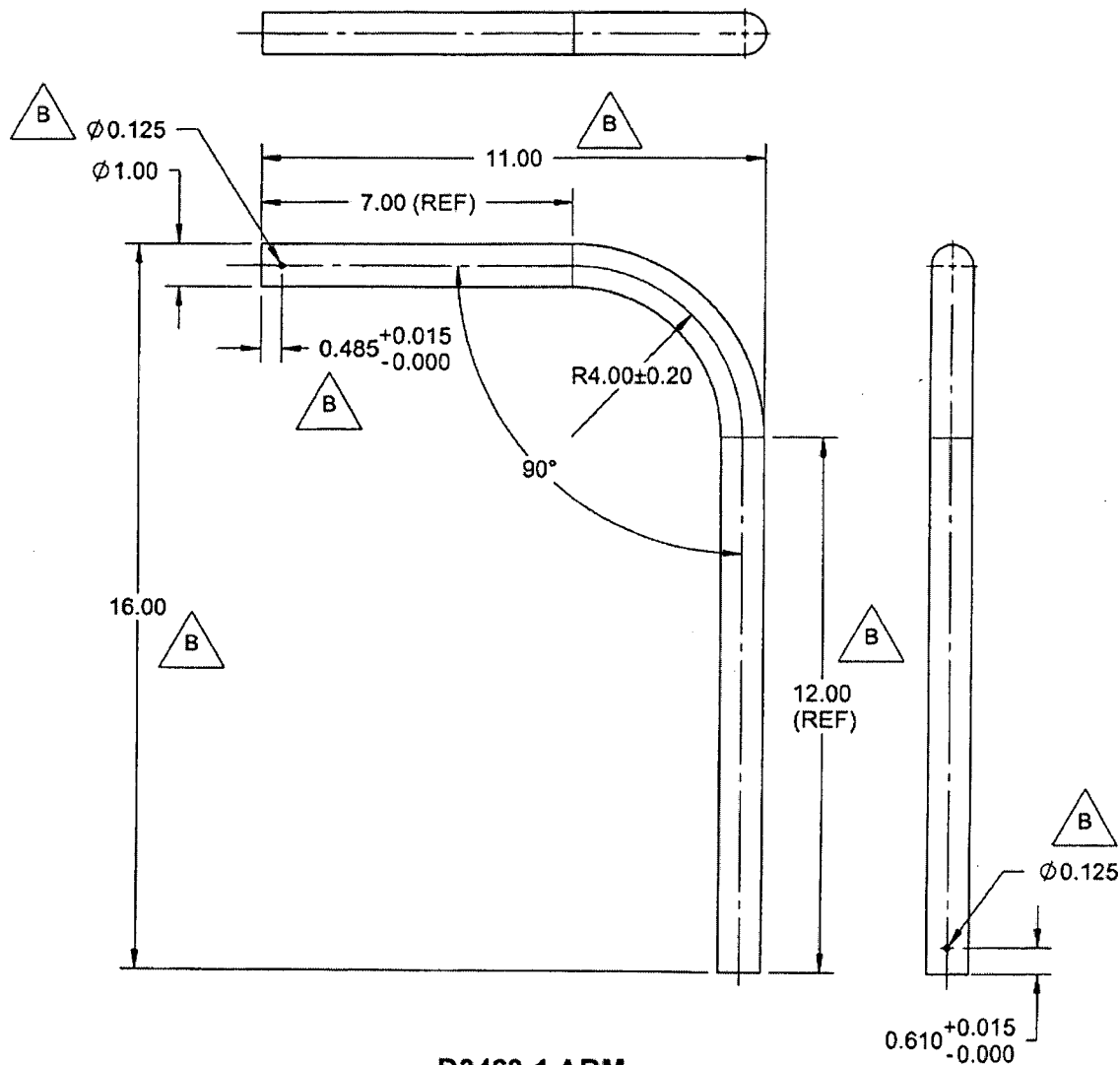
NO 33714

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DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

**RELEASED**05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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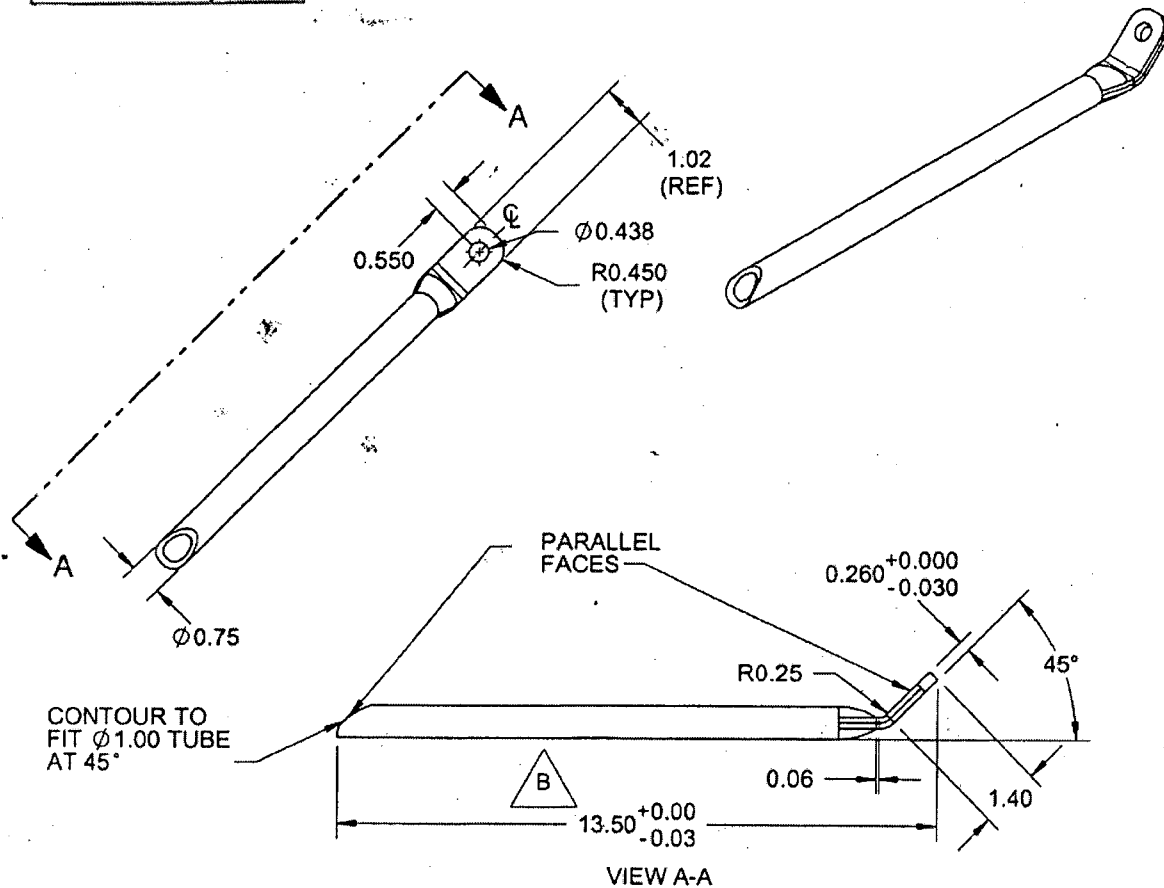
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 #



**D3463-7 DRAG ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010.

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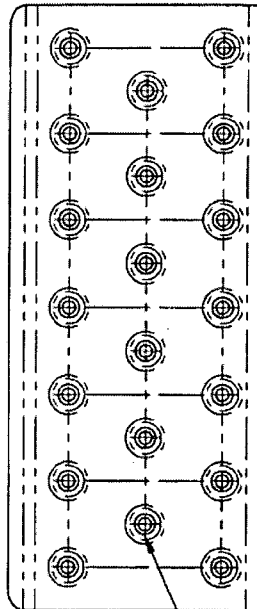
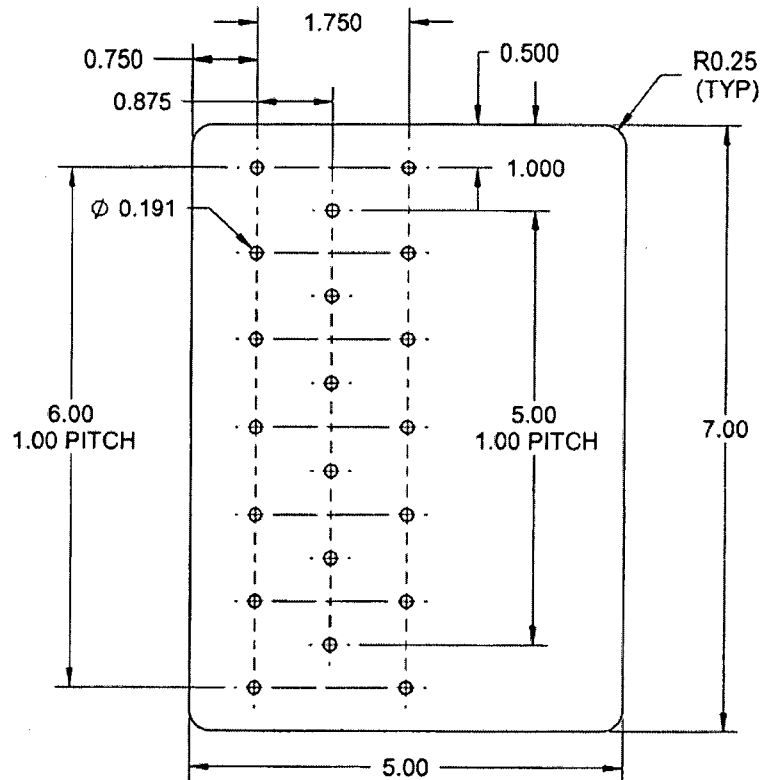
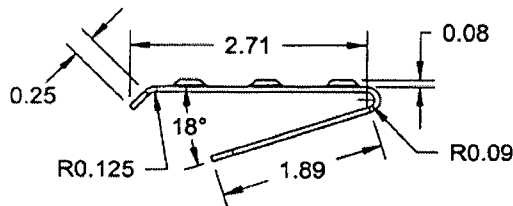
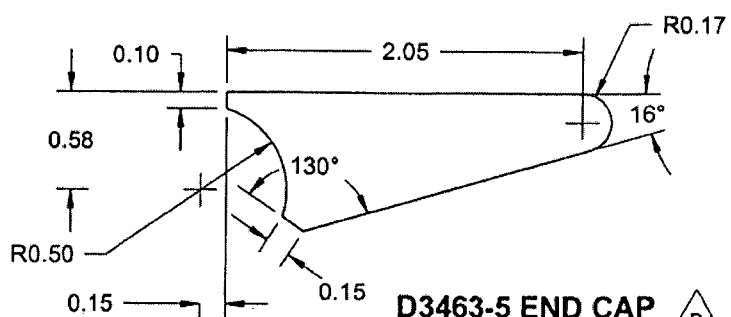


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DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:2

**RELEASED**

05.12.09 #

**FORM USING  
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP  
SCALE 1:1****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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